

# Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011

Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011

Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B 11-7-13

(24)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

H311-7-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71572

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Item ID: D3414-041

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Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/10/13

count  
724

Quality Control

130

0.00



Brake NC

Memo

0.00

SB 11/07/14

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

140

0.00



Large Fab

Memo

0.00

1- Weld using location Jig DT9625 as per Dwg D3414  
A/R S.S. welding rod Batch: M117659

EL 11-8-2

116  
P10

Large Fab

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-07-28	140	Stock 2 x D3414-1 undersize B/N	EL	11-7-28	1	L 11-07-28	S 11/08/28

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 71572

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Item ID: D3414-041

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Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.08.03

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 ulos/03

416

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00 AM  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 7:30 AM

m118439

16 of 11/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



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Item ID: D3414-041

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Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

16x ~~Ø~~ M-11/08/04

190

Identify as per dwg & Stock Location: 1179

0.00



Packaging

Memo

0.00

Packaging

11/8/04 16x Ø P

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/08

11-08-5 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Wednesday, July 06, 2011 1:20:11 PM

Work Order ID: 71572

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

147.3000

0.155

2.48



304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT019

147.3

113062

118.3

113077

29

D3414-3

Manufactured

No

140

Each

21.0000

1

16



Lug

Location

Loc Qty

Loc Code

WA

21

69882

21

70412

X16



B11-7-13

(24)

1307



Q 11-8-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

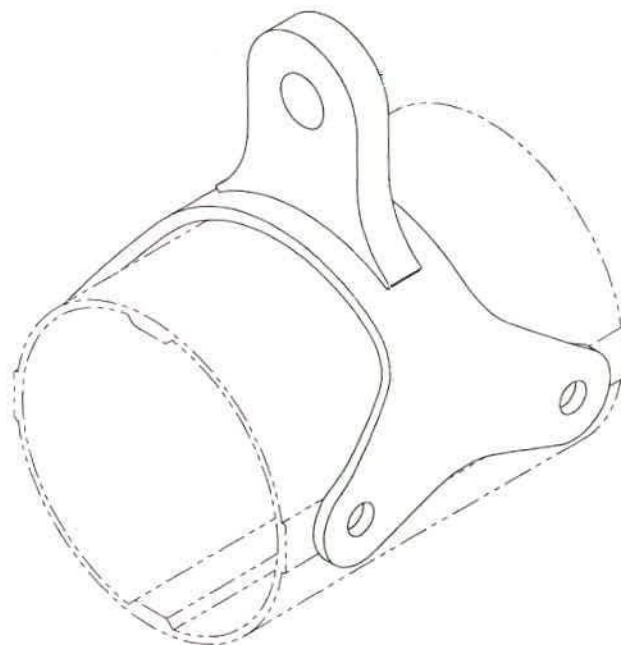
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



**D3414-041 LUG ASSEMBLY**

**NOTES:**

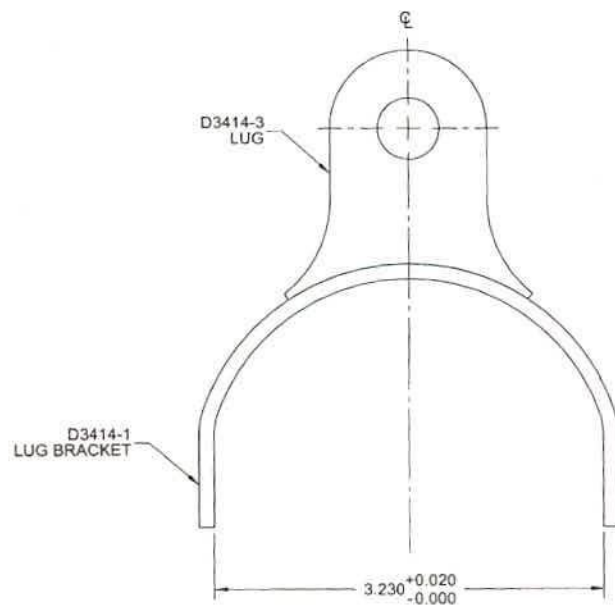
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

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WITHOUT NOTICE  
WORK ORDER  
NO. 71572

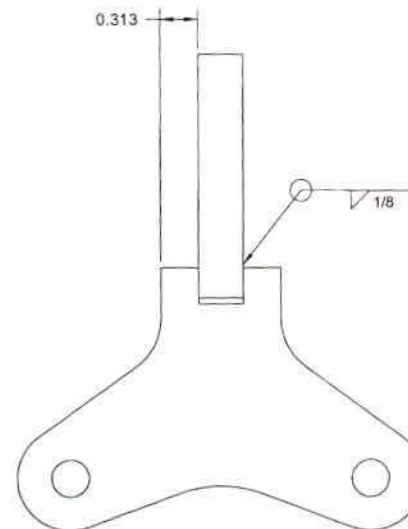
*CL11107106*

**RELEASED**  
*5/16/16*

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL. (SEE PAR 198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3414</b> REV. C <b>LUG ASSEMBLY</b> SCALE NTS <small>COPYRIGHT © 2015 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP		
DATE	09.06.17		



**D3414-041 LUG ASSEMBLY**

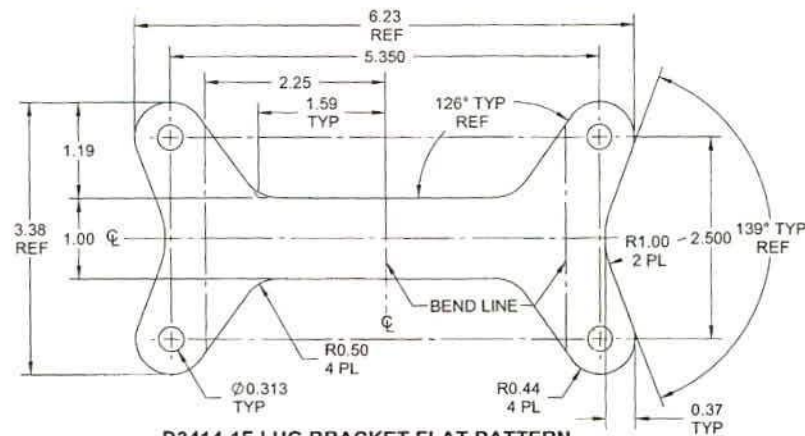


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WORK ORDER  
NO. 71572

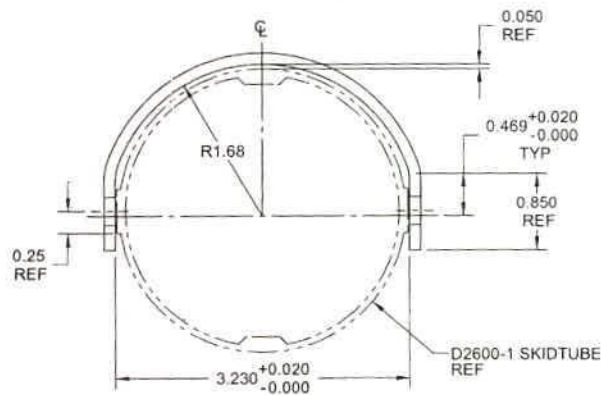
**RELEASED**  
09/10/17

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.	CP	TITLE	SHEET 2 OF 3
APPROVED	CP	<b>LUG ASSEMBLY</b>	SCALE
DE APPR.	CP		NTS
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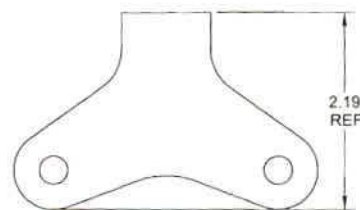




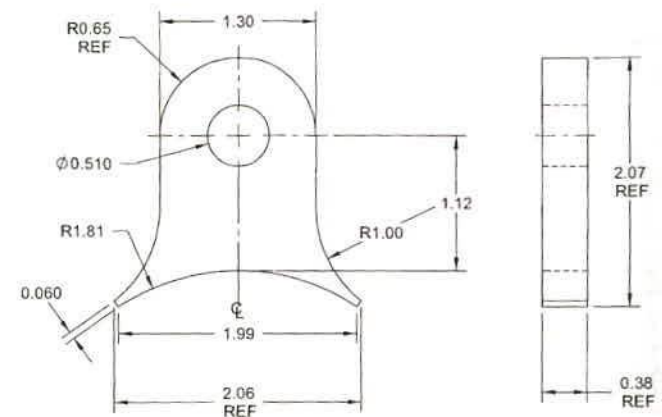
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



**SIDE VIEW FOR REF ONLY**



**D3414-3 LUG**

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WITHOUT NOTICE  
WORK ORDER  
NO. 71572

**RELEASED**  
09/06/17

NOTES:  
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A  
7) WEIGHT: N/A

DESIGN	QP	<b>DART AEROSPACE LTD</b>	
DRAWN	QP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QP	DRAWING NO.	REV. C
MFG. APPR.	QP	D3414	SHEET 3 OF 3
APPROVED	QP	TITLE	SCALE
DE APPR.	QP	LUG ASSEMBLY	NTS
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